



Ship Via:

DAS
64
9-89



				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	20 pcs	1/20/20	0.00 0.39	Handfinish - 1 - 1 - B4B	BEB 20-03-25
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	20 pcs	1/20/20	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	20 03-25
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				Plex 11/28/19 9:04 AM Dart.Renwick.Jennife	

25 38 0.89

					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
160 Powdercoat - 1 White Gl(A)- B4B	20 pcs	1/20/20	0.00 0.27		Powdercoat - 1 - B4B	
START: 2:40 OUT: 1:30 FINISH: 3:10					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	20. 3.25
					Powdercoat - 4 - B4B	
170 QC 3	20 pcs	1/20/20	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	20. 03.26
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
180 Packaging 3-1 - Stock - B4B	20 pcs	1/20/20	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	

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				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	20	1/20/20	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	6-21

MAR 26 2020

Part Op 100 - (Bandsaw) Cut blanks 4.425"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FA940 FOLIO REV: AA

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - QC7-Inspect Chemical Conversion Coat

160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X2.000	6061T6 Bar 1.250 X 2.000	7.4000 ft (.37 ea)	100-Bandsaw - 1	5216003 = 7.40

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X2.000	7	44	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	4.300inches $\pm$ 0.010	4.310 4.290		
2	Hinge Bracket	4.000inches $\pm$ 0.010	4.010 3.990		
3	Hinge Bracket	0.340inches $\pm$ 0.010	0.350 0.330		
4	Hinge Bracket	1.110inches $\pm$ 0.005	1.115 1.105		
5	Hinge Bracket	1.790inches $\pm$ 0.010	1.800 1.780		
6	Hinge Bracket	1.320inches $\pm$ 0.005	1.325 1.315		
7	Hinge Bracket	2.000inches $\pm$ 0.010	2.010 1.990		
8	Hinge Bracket	0.340inches $\pm$ 0.010	0.350 0.330		
9	Hinge Bracket	0.447inches $\pm$ 0.010	0.457 0.437		
10	Hinge Bracket	0.171inches $\pm$ 0.005 - 0.000	0.176 0.171		
11	Hinge Bracket	0.147inches $\pm$ 0.010	0.157 0.137		
12	Hinge Bracket	0.376inches $\pm$ 0.010	0.386 0.366		
13	Hinge Bracket	0.126inches $\pm$ 0.010	0.136 0.116		
14	Hinge Bracket	0.063inches $\pm$ 0.010	0.073 0.053		
15	Hinge Bracket	0.166inches $\pm$ 0.005 - 0.000	0.171 0.166		
16	Hinge Bracket	0.911inches $\pm$ 0.010	0.921 0.901		
17	Hinge Bracket	0.600inches $\pm$ 0.010	0.610 0.590		
18	Hinge Bracket	0.125inches $\pm$ 0.010	0.135 0.115		
19	Hinge Bracket	0.150inches $\pm$ 0.010	0.160 0.140		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 203851
Description: Hinge Bracket		Part Number: D2857-2
Inspection Dwg: D2857	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.300	✓		high gauge	31006
4.000	+/-0.010	3.999	✓		high gauge	31006
0.340	+/-0.010	.340	✓		vernier	B17321453
1.110	+/-0.005	1.108	✓		vernier	B17321453
1.790	+/-0.010	1.790	✓		vernier	B17321453
1.320	+/-0.005	1.318	✓		vernier	B17321453
2.000	+/-0.010	1.998	✓		vernier	B17321453
0.340	+/-0.010	.337	✓		vernier	B17321453
0.447	+/-0.010	.445	✓		high gauge	31006
Ø0.171	+0.005/-0.000	.174 Ø	✓		pin gauge	(REF)
0.147	+/-0.010	.144	✓		vernier	B17321453
0.376	+/-0.010	.377	✓		vernier	B17321453
0.126	+/-0.010	.127	✓		vernier	B17321453
0.063	+/-0.010	.063	✓		vernier	B17321453
Ø0.166	+0.005/-0.000	.166 Ø	✓		pin gauge	(REF)
0.911	+/-0.010	.912	✓		high gauge	31006
0.600	+/-0.010	.599	✓		vernier	B17321453
0.125	+/-0.010	.125	✓		vernier	B17321453
0.150	+/-0.010	.150	✓		vernier	B17321453

Measured by: M. M. 64	Audited by: mk	Preliminary Approval:
Date: 2020/03/19	Date: 20/03/24	Date:

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	
C	12.10.15	Dimensions update per Dwg Rev C	KJ	